Quality Control

Page 1

Tuesday, November 26, 2013 1:38:25 PM Item ID: D3016-041 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Seat Frame Assembly Start Date: 11/26/2013 | Start Oty: 1.00 **Cust Item ID:** Required Date: 12/3/2013 Req'd Oty: 1.00 **Customer:** Reference: Run Date: 13 - 11-26 Tooling: Process Plan: M. Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Qty **Run Hours** Qty Code Number Stamp **Draw Nbr Revision Nbr** D3016 RevA / DEO A-1 100 Weld per dwg A/R 4130 rod Batch: MOOOS 0.00 Large Fab *100* Large Fab 0.00 Memo Large Fab 1-Cut all tubes as per Dwg D3016 2-Deburr 🗻 3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597 4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041 5- Assemble brackets and gusset per dwg and weld 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 A/ EL 13-12-3 0 *110* OC 0.00 Memo

												DQA:	Date	e:	
NCR: Y	es	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:	Date		
					•			_				QA Closed:	Date	2.	
Vork Orde	r.						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	•					٠ ا	Rework	1		Skid-tube	Crosstube	7	Water Jet	☐ Er	ngineering
Part N	o.						Scrap	1 1	r	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	-						Use-as-is		Therm	oforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	lo.					.	Work Order Update			Large Fab	Composite		Supplier		
				r		_						T 0: 0		1	
Root			.		Des	•	tion of work order update		nitial		tion	Sign &	Marification		OC Increases
Cause	4	Date	Step	Qty			r Non-conformance	Cn	ief Eng	Desci	ription	Date	Verification	-	QC Inspector
oc/Data	┈														
quip/Tooling perator	\dashv													İ	
laterial	ᅱ														
etup	-												Ì		
ther	\dashv												ļ		
rocess															
upplier]												
raining								1				1	1		
napproved															
							F	AUL	T CATE	GORY					
Landi	ng G	ear					General					7	_	_	
		Bending					Bend	<u> </u>	Grain			Ovalized		 ∤	ssure/Forced
		Centre No	ot Conce	ntric to	o/s		BOM/Route		Hardwa		<u> </u>	Over/Under	⊢	_	nperature/Cure
		Cracks Broken/Damaged					_	<u> </u>	4 '	on incomplete	L	Part Incorre	<u> </u>	Wel	
		Crushed/Crimped Burrs						_	-	ions Incomplete/	Unclear	Part Lost/M	٠ ـ	JWrc	ong Stock Pulled
		Cuffs					Contamination	-	Mainte			Part Moved		•	
	Heat Treat Countersink							-	Mislabe		<u> </u>	Positioned V		٦٠٠٢	0.5
						-	Cut Too Short	\vdash	Misread	1		Power Loss/	Surge [Oth	er
	Ripples in Bend Drill Holes						4	Offset Out of Calibration							
	H						Drawing Finish	\vdash	-	Lalibration Sequence				 · -	
	l	Turning S	equence	!		1	rinisn	1	Logic of 3	equence	*				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

109707

Work Order ID 109707

Tuesday, November 26, 2013 1:38:25 PM

Item ID: **Revision ID:** D3016-041

Item Name:

Seat Frame Assembly

Start Date:

11/26/2013 | Start Qty: 1.00

Required Date: 12/3/2013

Req'd Oty: 1.00

N900040100

Setup Start

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date:

Accept

Tooling:

SPC (Y/N):

Date: Date:

Run

Sequence ID/ Work Center ID 120

120 OC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

0.00

0.00

0.00

Tool ID Tool #

Accept Plan Code Qty

Reject Qty

Reject Number Stamp

Insp.

130

130 Powdercoat

Powder Coating

Memo

Memo

Install paint screws on fitting ends

140

QC

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

QC3- Inspect Part Finish

Memo

0.00

0.00

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
			OA Closed:	Date:	

										QA Closed.	Date	•	
Work Orde	er:					DISPOSITION							
Part N						Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Quality ng Rec/Store/Packaging Other			
Root				I	Descri	ption of work order update	Initial	A	ction	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chief Er	g Des	cription	Date	Verification	QC Inspector	
Doc/Data		Î			' ''								
Equip/Tooling		Į.											
Operator													
Material										,		·	
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
						F	AULT CA	EGORY					
Landi	ng Ge	ear				General	_		_	1		 1	
		ending				Bend	Grain			Ovalized	<u> </u>	Pressure/Forced	
		entre No	t Concer	ntric to (o/s	BOM/Route	Hard			Over/Under		Temperature/Cure	
	⊢	cracks			_	Broken/Damaged	\vdash	ction Incomplete		Part Incorre	-	Weld	
		crushed/C	Crimped		<u> </u> _	Burrs	——	ictions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	——	Cuffs			<u> </u>	Contamination	-	itenance		Part Moved			
	${f H}$	Heat Treat				Countersink	$\boldsymbol{\vdash}$	beled	<u></u>	Positioned V	_	–	
		Inspection Strip in Tube			_	Cut Too Short	Misre			Power Loss/	Surge	Other	
	-	Ripples in			<u></u>	Drill Holes	Offse						
	$\boldsymbol{\vdash}$	orque W			י 📙	Drawing	\vdash	of Calibration					
	Turning Sequence					Finish		of Sequence					
	1 IN	Wave/Twist in Tube				Folio	1 IOuts	de Dimensions					

109707 Tuesday, November 26, 2013 1:38:25 PM Item ID: D3016-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Seat Frame Assembly Start Date: 11/26/2013 Start Qty: 1.00 **Cust Item ID:** Required Date: 12/3/2013 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: **Tooling:** Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Accept Reject Work Center ID Description Run Hours Qty Code Qty Number 150 Identify as per dwg & Stock Locatio 0.00 *150* Packaging 0.00 Memo Packaging

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00 Memo

MLJ 13-12-05 MLJ 13-12-05

Insp.

Stamp

												DQA:	Date	e:	•
NCR: Y	'es	/ No					WORK ORDER NON-C	CON	VFORM	MANCE / UP	DATE	QA Closed:	 Date	٠. 	
							DISPOSITION				AGAINST DI	EPARTMENT,			
Nork Orde	er:					ı	F	,			_	7	_	- -	🗂 1
Part N	lo.						Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	-	ngineering Quality Other
NCR N	lo.		<u></u>				Work Order Update Large Fab Composite					Supplier			
Root					Des	crip	tion of work order update		nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification		QC Inspector
oc/Data quip/Tooling											•				
perator			(}										1	
laterial				į						,					•
etup		i			•										
ther															
rocess															
upplier								l							-
raining															
napproved		L													
								AUL	T CATE	GORY					
Landi	ng (1			!		General				_	7	г	_	_
		Bending					Bend	_	Grain		<u> </u>	Ovalized		⊣	essure/Forced
	<u> </u>	Centre Not Concentric to O/S					BOM/Route	<u>_</u>	Hardwa		<u> </u>	Over/Under		—-	mperature/Cure
	_	Cracks					Broken/Damaged	\vdash	-1 `	on Incomplete		Part Incorre	} —	– We	1
	_	Crushed/Crimped					Burrs	<u> </u>	-1	ions Incomplete/	Unclear	Part Lost/M	issing [_Jwr	ong Stock Pulled
		Cuffs					Contamination	\vdash	Mainte			Part Moved	• • • • • •		
	Heat Treat						Countersink	\vdash	Mislabe		<u> </u>	Positioned \		الم	.
	Inspection Strip in Tube					\vdash	Cut Too Short	-	Misread	ז	L	Power Loss/	Surge	Otl	ner
							Drill Holes	\vdash	Offset	~_!:bk:					
	Torque Waves in Extrusion Drawing						1 -	Out of Calibration Out of Sequence							
	Turning Sequence					1	Finish ,	L	JOUT OF:	sequence					

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

چر س

Picklist Print

Tuesday, November 26, 2013 1:38:24 PM

Work Order ID:

109707

Parent Item:

D3016-041

Parent Item Name:

Seat Frame Assembly

Start Date: 11/26/2013

Required Date: 12/3/2013

Start Qty: 1.00

Required Qty: 1.00

							- -			
Comments: IPP A01.09.191	New issueECIPP RevB: as	per revB DD ve	rified by:JLM							
Component Item ID/ Item Name Replacement Item ID	Mfg/ Bin Purch Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Issued Issued	Status
M4130NT0.750W.049 4130 RD Tube .750 x.049W	Purchased No.			100	f	272.6252	4.3	5	5 13-12-9	22 M
· ·		<u>Location</u>		Loc Qty	<u>Lo</u>	oc Code				
•		MAT033		272.6251893						
;	· •	1233:	-	2.1217893						
		₹ (1252)		12.7164						
į.	Manager ;	1253 m127		91.614 166.173						
M4130NT0.500W.049	Purchased No			100.173	f	134.1260	4.3	5		
4130 RD Tube .500 x.049W						151200			(5) 13-12	3-03 BD
į		Location		Loc Qty	Lo	e Code				
		MAT032		134.126	20	- Cour				
!		1210	25	1.82						
		12333	39	16.596				<u>, + </u>		
		12429		19.71						
		m127	· ·	96				5		
M4130NT1.000W.120	Purchased No.	•		100	f	32.2325	1.5	2		C2.5
4130 RD Tube 1.00 x .120wall								e e e e e e		5.00 KD
\(\frac{\frac{1}{3}}{3}\)		Location		Loc Qty	. <u>Lo</u>	c Code				
\mathcal{O}		MAT033		32.2325			\overline{MM}	ا ٦- صادما		
(12429		9.71			MIN	1973 > 1		
D3016-17	Manufactured No	m126	0343	22.5225 100	Each	22.0000				
Gusset	Manufactured No.	'		100	Each	32.0000	2	2	(2) 121	J.02 D
04000		Lagation		1 04-		6 1	w winne.	₹ V5 * 12 * 12 ± 12 1		.a. 00 15
		Location WA002		Loc Qty	Lo	c Code			*	
		WA002		32 32					No.	
		1.007-	· /	J2			•			

Page 1

			DQA:	Date:
NCR: Yes	No WORK ORDER NON-CONF	ORMANCE / UPDATE		

									<u></u>		QA Closed:	Dat	e:
Work Orde	er:					DISPOSITION			protection of the control of the con	AGAINST DE	PARTMENT	/PROCESS Water Jet	
Part NCR 1	•					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro Rec/Sto	Engineering Quality Other	
Root					Descri	ption of work order update	lr	itial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	 										ĺ		
Material	. +-1 1 1 1											<u> </u>	
Setup													
Other												1	
Process							1						
Supplier								•			1	1	
Training							1						
Unapproved											<u> </u>		
							AUL	CATE	GORY				
Landi		•			·	General	_			_	7	ŗ	
		Bending				Bend		Grain		_	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under		Temperature/Cure
Ì	⊢	Cracks				Broken/Damaged	-	•	on Incomplete		Part Incorre		Weld
	┕	Crushed/	Crimped		_	Burrs	\vdash		ions Incomplete/	/Unclear	Part Lost/M	issing [Wrong Stock Pulled
:	<u> </u>	Cuffs			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved		
	<u> </u>	Heat Treat				Countersink	\vdash	Mislabe		<u> </u>	Positioned \	- r	
	Inspection Strip in Tube			Tube	<u> </u>	Cut Too Short	\vdash	Misread	t	L.	Power Loss/	'Surge	Other
1	Ripples in Bend				<u> </u>	Drill Holes	-	Offset					
	<u></u>	Torque W			n ⊨	Drawing	\vdash		Calibration		····		
	<u> </u>	Turning S			\vdash	Finish	Out of Sequence						
	Wave/Twist in Tube				1	Folio		Outside	Dimensions				

Tuesday, November 26, 2013 1:38:25 PM

Work Order ID:

109707

Parent Item:

D3016-041

Parent Item Name:

Seat Frame Assembly

Start Date: 11/26/2013

Required Date: 12/3/2013

Start Oty: 1.00

Required Qty: 1.00

D3016-13

Bracket

Manufactured No 100

Each

7.0000

2

D3016-15

Gusset

D3020-1 Fitting

Manufactured

Manufactured

No

No

WA001 100818

100

Loc Qty

100

Loc Qty

7

Each

1.0000

Loc Code

Location

Location

WA001 95695

Each

Loc Code

Loc Code

34.0000

B97657 -> 2

Location WA002

107909

Loc Qty 34 19 15

			DQA:	Date:
VCR· Ye	es / No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Date	e:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	٠ . No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosste Machining Small Thermoforming Finish Large Fab Compo			Prod Rec/Stor	Engineering Quality Other	
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	hief Eng Description			Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup												:	
Other		ĺ											
Process							1						
Supplier													
Training			ŀ										
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General		_			_	_	
}		Bending				Bend		Grain			Ovalized	L	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks			L	Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct _	Weld
		Crushed/	Crimped			Burrs	L	Instruct	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Treat				Countersink		Mislabe	eled		Positioned V		_
	Inspection Strip in Tube					Cut Too Short	L	Misrea	t		Power Loss/	Surge	Other
	Ripples in Bend					Drill Holes		Offset					
	Torque Waves in Extrusion				Drawing	L	Out of	Calibration					
	Turning Sequence Fir					Finish		Out of	Sequence				
	Wave/Twist in Tube					Folio	1	Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





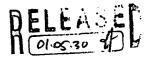
DESIG	\ CP	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
CHECK	KED ,	APPROVED	DRAWING NO.	REV. A
	#	A -	D3016	SHEET 1 OF 3
DATE			TITLE	SCALE
01.0	05.18		SEAT FRAME ASSEMBLY	NTS
Α		01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
Х	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A
	1 2 1 2 1 1 1 1	NUMBER X D3016-041 1 D3016-1 2 D3016-3 1 D3016-5 2 D3016-7 1 D3016-9 1 D3016-11 1 D3016-13 1 D3016-15 1 D3016-17	NUMBER X D3016-041 SEAT FRAME ASSEMBLY 1 D3016-041 TUBE ASSEMBLY 2 D3016-1 TUBE TUBE TUBE TUBE TUBE TUBE TUBE TUBE

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEO ATTACHED



Copyright © 2001 by DART AEROSPACE LTD

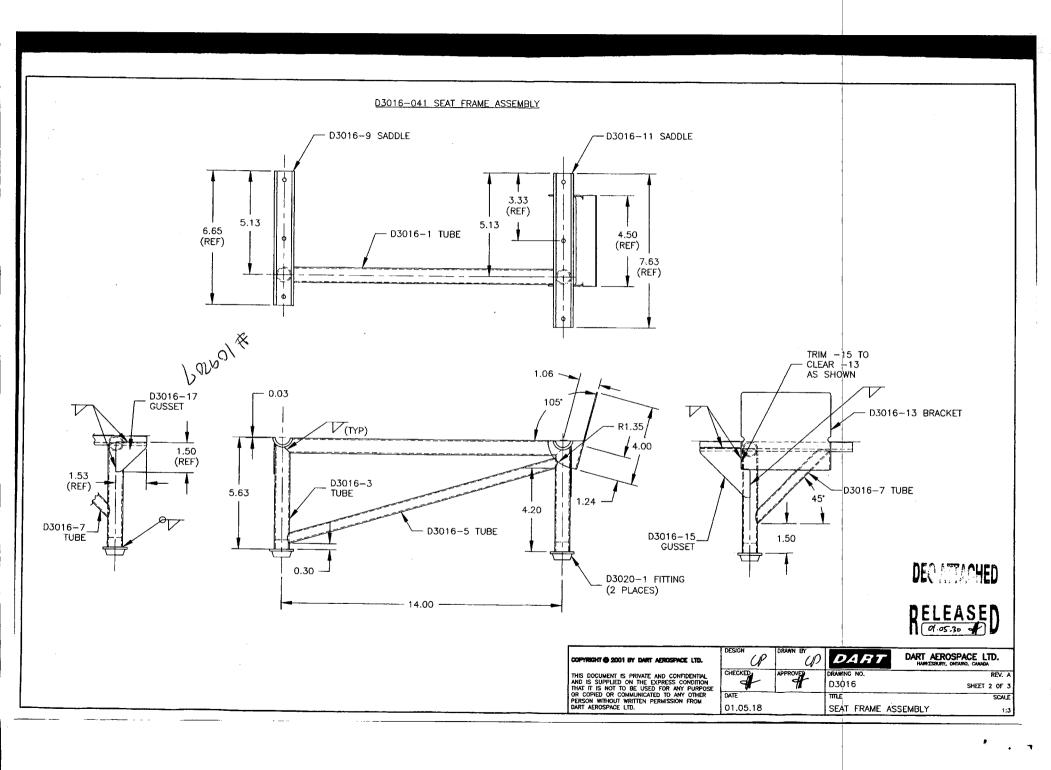
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

									DQA:	Date:	±
NCR: Y	es / No			WORK ORDER	R NON-COI	NFORN	AANCE / UP		QA Closed:	Date:	
Work Orde	. .			DISPOSIT	ION			AGAINST DE	PARTMENT	/PROCESS	
Part No	0.			Us	Scrap Machining Small I Use-as-is Thermoforming Finish		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root				Description of work order	update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	or Non-conformance	e Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material					·						
Setup					· [
Other											
Process								:			
Supplier											
Training					ł						

Landing	Gear	General		_	_	_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
-	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	_
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Г	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

FAULT CATEGORY

Unapproved

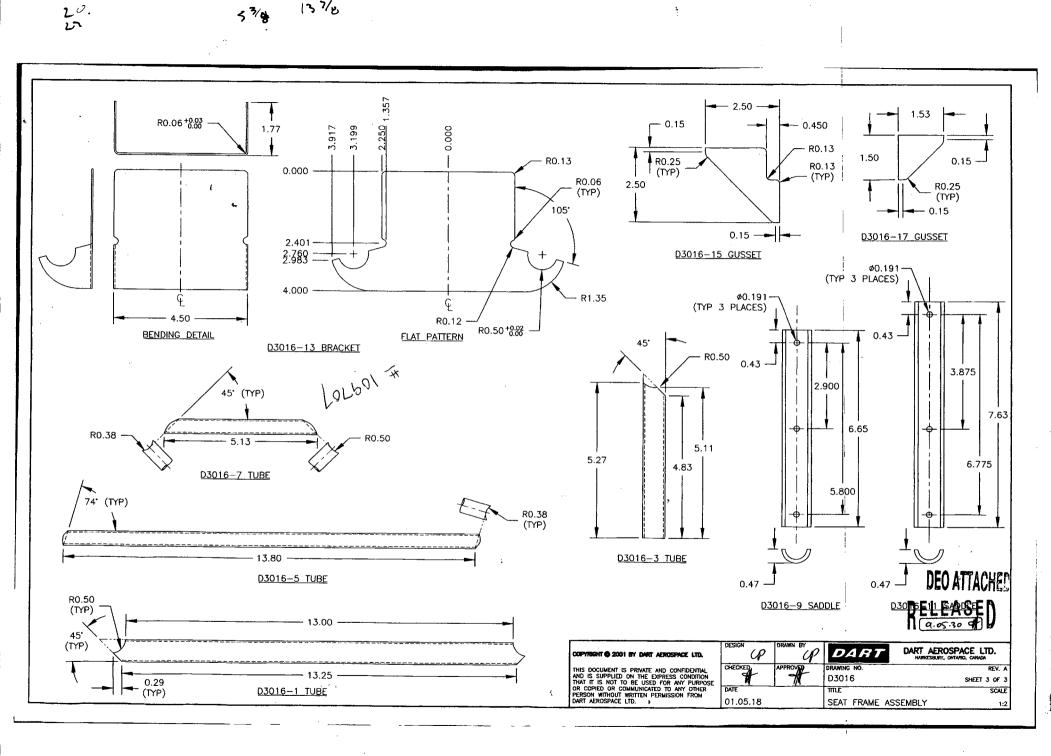


		DQA:	Date:	
 	 MANDE ADDED MAN COMEADMANICE / LIDDATE			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	•	
Work Orde					DISPOSITION			AGAINST DE	DEPARTMENT/PROCESS			
Part No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstub Machining Small Fa Thermoforming Finishin Large Fab Composit			Pro Rec/Sto	Engineering Quality Other		
Root			I I	Descri	ption of work order update	Initial	Initial Action					
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training												
Unapproved			<u> </u>		F	AULT CATE	GORY		1 -	<u> </u>		
Landir	ng Gear				General	AOEI CAIL		*				
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Instruct Mainto Mislabo Misrea Offset Out of	ion Incomplete tions Incomplete, enance eled d Calibration	/Unclear	Ovalized Pressure/Forced Over/Under tolerance Temperature/Cure Part Incorrect Weld Part Lost/Missing Wrong Stock Pulled Part Moved Positioned Wrong Power Loss/Surge Other			
		Sequence		<u> </u> _	Finish	\vdash	Sequence e Dimensions					
	Wave/T	wist in Tu	be		Folio A							



				DQA:	Date:	• '	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE				

NCR:	Yes /	No	WORK ORDER NON-CONFO
------	-------	----	----------------------

	,							•		QA Closed:	Dat	te:			
Work Ordei	·				DISPOSITION				AGAINST D	INST DEPARTMENT/PROCESS					
Part No					Rework Scrap Use-as-is The			Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Quality			
NCR No	o				Work Order Update]	Large Fab Composite				Supplier				
Root	oot Des				ption of work order update	l i	nitial	Ac	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	n QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
· · · · · · · · · · · · · · · · · · ·	!				F	AUL	T CATE	GORY		1					
Landin	g Gear				General		-					_			
	Bending Centre Not Concentric to O/S Cracks			o/s	Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			Ovalized Over/Under Part Incorre	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled				
	Crushed/ Cuffs	Crimpea		-	Burrs Contamination	\vdash	4	tions Incomplete/ enance	Officiear	Part Moved	12211 B	Wrong Stock Funed			
Ţ	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong				
	Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other			
Ţ	Ripples in	n Bend			Drill Holes		Offset								
[Torque V	Vaves in I	Extrusio	n [Drawing		Out of	Calibration				·			
	Turning S	Sequence			Finish		Out of:	Sequence							
	Wave/Twist in Tube				Folio		Outside Dimensions								

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

23.8 E. 18.8

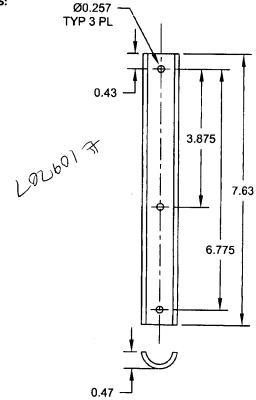
DRAWING NO). TITLE			REV. A	DART AE	ROSPACE LTD	D.E.O. N	10.	SHEET NO.	SCALE
D3016	SEAT FR	AME ASSEM	BLY	_		ERING ORDER	D3016	-A-1	SHEET 1 OF 1	NTS
DRAWN	1	CHECKED	A)	MFG. APPR.	R	APPROVED	M	DE APPR.	
DATE '	10.01.29	DATE	10.0	1.25	DATE	10,01.29	DATE	10.01.29	DATE 10-01-29	

<u>PURPOSE:</u> TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

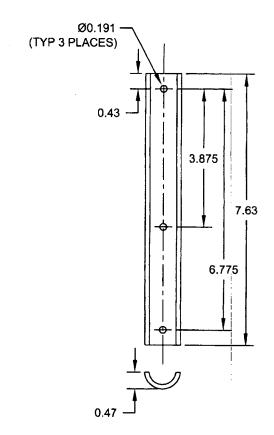
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

COPYRIGHT © 2010 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICAL ETO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

										DQA:	Date: _				
NCR: Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE						Date:				
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No			Rework Scrap Use-as-is Work Order Update	Ther		Skid-tube Crosstube Machining Small Fab ermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other					
Root				Descri	ption of work order update	In	itial	Act	tion	Sign &		•			
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other															

Landin	g (Gear	 General	_				 -
ſ		Bending	Bend		Grain		Ovalized	Pressure/Forced
		Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
[Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
ſ		Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
		Cuffs	Contamination		Maintenance		Part Moved	
		Heat Treat	Countersink		Mislabeled		Positioned Wrong	
		Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
		Ripples in Bend	Drill Holes		Offset			
		Torque Waves in Extrusion	Drawing		Out of Calibration			
		Turning Sequence	Finish		Out of Sequence			
		Wave/Twist in Tube	Folio		Outside Dimensions		v	

FAULT CATEGORY

Process
Supplier
Training
Unapproved